

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-016899**Date Inspected:** 13-Sep-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Liu Hua Jie**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Orthotropic Box Girder(OBG)**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Manoj Prabhune was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

This QA Inspector randomly observed the following work in progress:

OBG # TRIAL ASSEMBLY YARD**Segment # 10AW ~ 10BW**

During random visual inspection this Caltrans Quality Assurance (QA) inspector observed that American Bridge Fluor (ABF) Quality Assurance (QA) personnel had performed Magnetic Particle Testing (MT) on Bottom Plate to Side Plate Transverse CJP Weld. in OBG segment 10AW ~ 10BW. See the attached Photo.

Segment # 10AE ~ 10BE

During random visual inspection this Caltrans Quality Assurance (QA) inspector observed that American Bridge Fluor (ABF) Quality Assurance (QA) personnel had performed Ultrasonic Testing (UT) on Edge Plate to Edge Plate Transverse CJP Weld. Weld joint identified as OBE10-005 in OBG segment 10AE ~ 10BE.

WELDING INSPECTION REPORT

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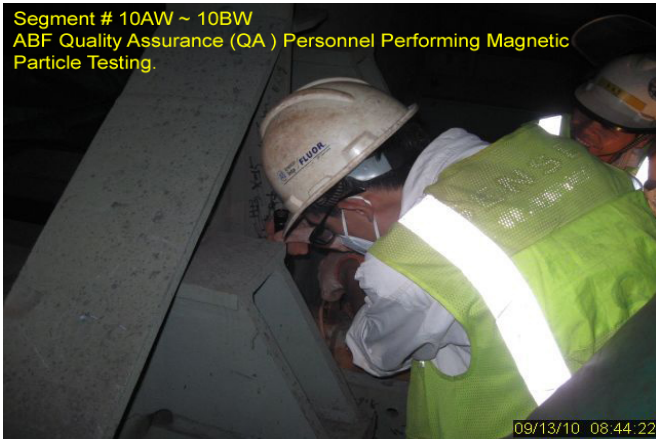
Segment # 10CW

During random visual inspection this Caltrans Quality Assurance (QA) inspector observed that ZPMC personnel had performed heat straightening on various locations on longitudinal Diaphragm in OBG segment 10CW at panel point 94. ZPMC QC is identified as Mr. Zhong Peng the variables recorded by QC appeared to comply with the Heat Straightening Report (HSR) was HSR1 (B) 9053. See the attached Photo.

Segment # 10BE ~ 10CE

During random visual inspection this Caltrans Quality Assurance (QA) inspector observed that ZPMC personnel had performed Fit-Up T-Rib Web to Web weld joint.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang phone: 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Prabhune,Manoj	Quality Assurance Inspector
Reviewed By:	Patterson,Rodney	QA Reviewer
